

Date: Wednesday, 9/27/2006 11:09:39 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HI-STEP LEG ASSEMBLY
Job Number	28738	Part Number	D3065041
Estimate Number	10385	Drawing Number	D3065 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	9/27/2006	Drawing Revision	B
Prsht Rev.	NC	Material	N/A
First Issue	9/27/2006	Due Date	10/10/2006
Previous Run	27590	Qty:	55
Written By		Um:	60
Checked & Approved By	<u>sf 06 09 2006</u>	Each	
Comment	Est Rev: 02.11.01	Incorporated D3066-1 IPP KJ/RF	

Additional Product

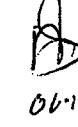
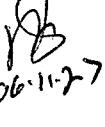
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	28738A	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3065-1 B <u>28738A</u>	55 mx <u>MF. 06-11-27</u>
2.0	28738B	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3065-3 B <u>28738B</u>	55 mx <u>MF. 06-11-27</u>
3.0	28738C	STEP LEG	
		Comment: Sub-Component STEP LEG D3065-5 B <u>28738C</u>	110 <u>MF. 06-11-27</u>
4.0	28738D	STEP SPACER	
		Comment: Sub-Component STEP SPACER D3065-7 B <u>28738D</u>	55 <u>MF. 06-11-27</u>
5.0	MS20470AD44	Rivet, Universal Head	
		Comment: Qty.: 30.0000 Each(s)/Unit Total: 1800.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch	<u>950 mx</u> <u>m102328 - 1000</u> <u>m100993 - 700 mx</u> <u>MF. 06-11-27</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/27	6	I part D3065-1 was snap hole was to open out of Tolerance	 DRAFT	Scrap + destroy replace it	813 06/11/27	 06/11/27	 64447	 06/11/27

NOTE: Date & initial all entries

Date: Wednesday, 9/27/2006 11:09:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 28738

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

mf. 06-11-01

55

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/27 55

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W 18, 19, 20, 21*

12-06-12-4 55

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12-06-12-4 55

Job Completion



12-06-12-4 55

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

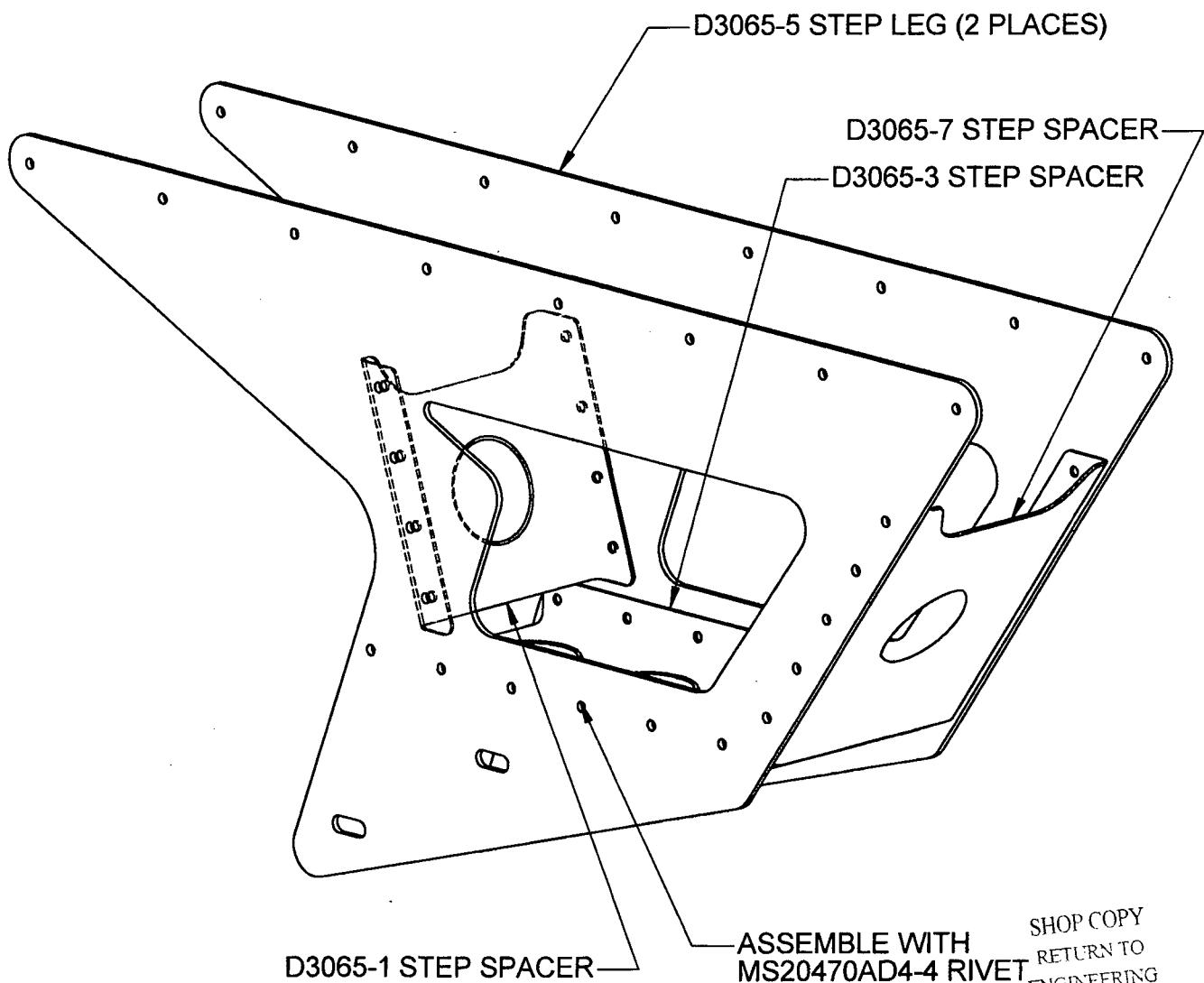
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	JK	DRAWING NO. D3065 REV. B SHEET 1 OF 5
DATE	06.05.23			TITLE STEP LEG ASSEMBLY SCALE 1:2
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED06.06.20 ~~JK~~**D3065-041 STEP LEG ASSEMBLY**

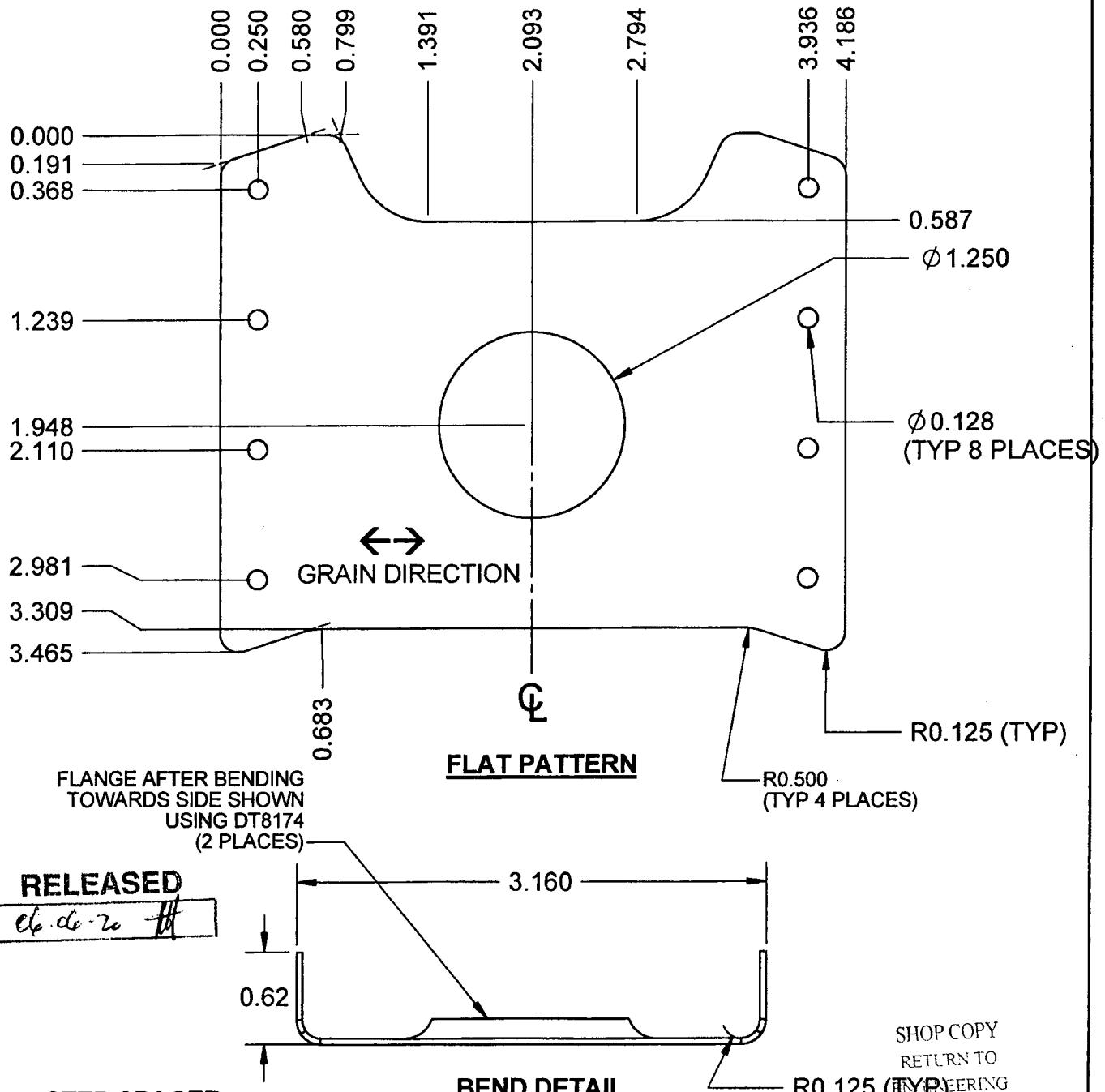
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28738

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DART

DESIGN	GP	DRAWN BY	CB	DART AEROSPACE LTD	
CHECKED	PH	APPROVED	<i>MM</i>	HAWKESBURY, ONTARIO, CANADA	
DATE	06.05.23	DRAWING NO.	D3065	REV. B	SHEET 2 OF 5
		TITLE	STEP LEG ASSEMBLY	SCALE	1:1

**D3065-1 STEP SPACER**

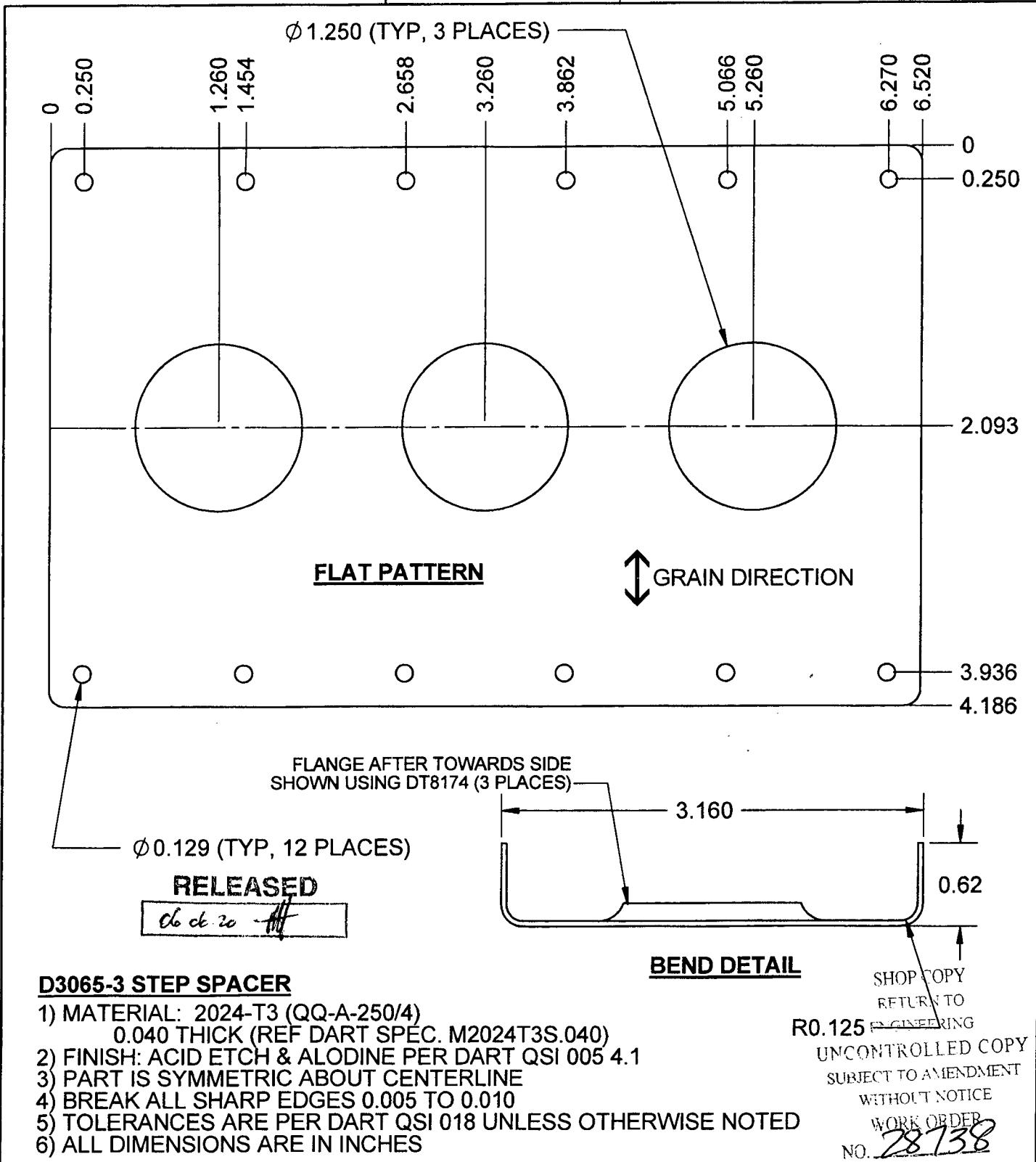
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 3 OF 5 SCALE 1:1

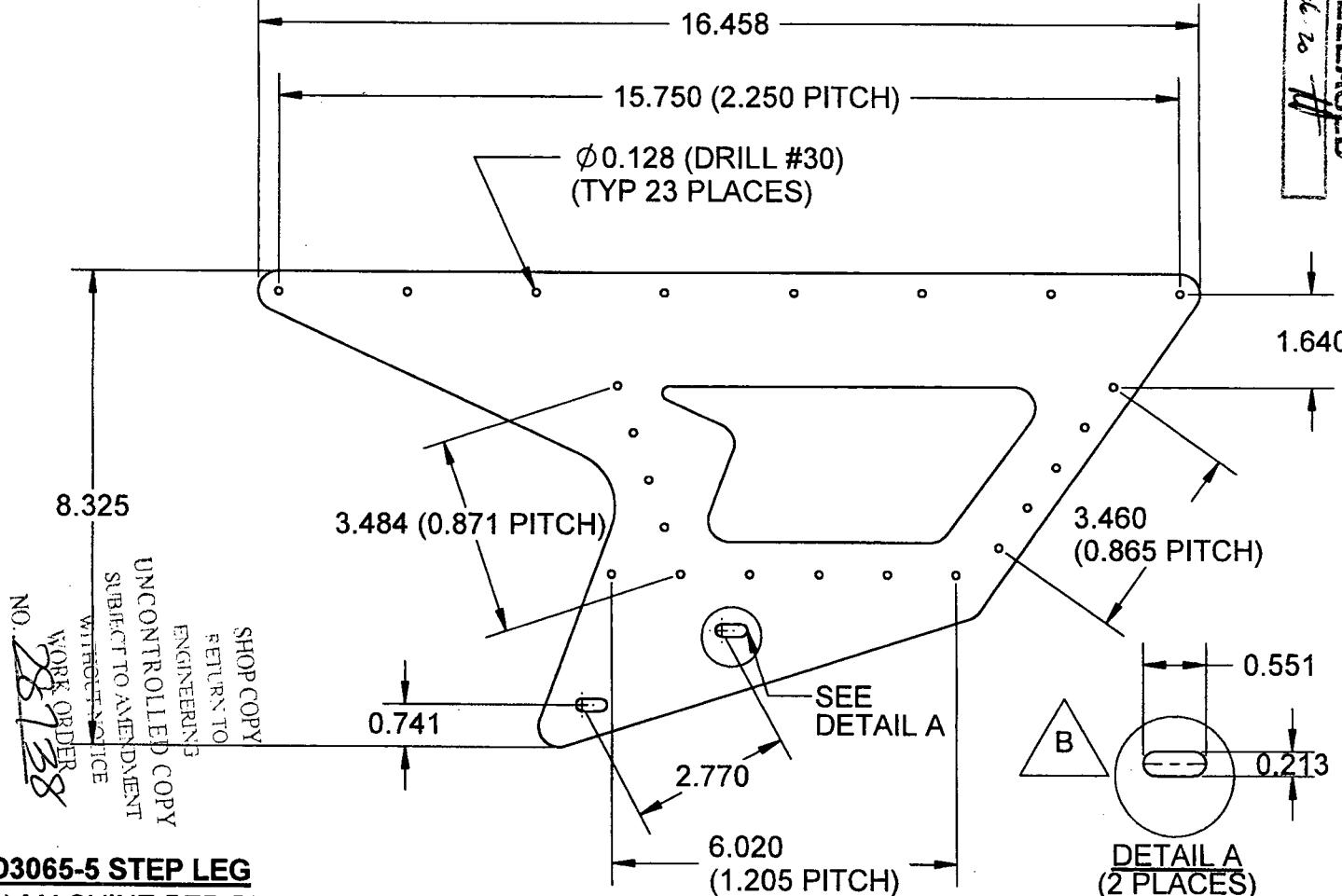


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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY
REV. B	SHEET 4 OF 5	SCALE 1:3

RELEASED
06.06.20 *H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

